

Work Order ID 166385

Tuesday, September 19, 2017

Page 1

Item ID: _____ **Revision ID:** _____**Item Name:** _____**Draw Nbr:** _____**Start Date:** 9/19/2017 12:**Start Qty:** 1.0000**Revision Nbr** _____**Required Date:** 9/19/2017 12:**Reqd Qty:** 1.0000**Reference:** ECN 17-628**Cust Item ID:** _____**Customer ID:** _____**Description:** PAPER WORK UPDATE PER ECN 17-628**Sales Order:** _____IIN D412-702 REV.H, IIN D412-702-1 REV.B ,IIN D412-702-2 REV.B ,IIN D 412-702-3 REV. C ,ICA
D412-702 REV.6

Approvals: **Process Plan:** ^{DAS} 21 **Date:** SEP 19 2017 **Tooling:** _____ **Date:** _____
⁹⁻⁸⁹
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Hours _____^{DAS}
28
⁹⁻⁸⁹**SEP 20 2017**

QC 21-17/9/21 JJ

List Lots

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Criteria : Item ID: 'D412-702-011', 'D412-702-013', 'D412-702-019', 'D412-702-021', 'D412-702-023', 'D412-702-025', 'D412-702-043B', 'D412-702-045B', 'D412-702-059', 'D412-702-069', 'D412-702-071', 'D412-702-075', 'D412-702-101A', 'D412-702-101B', 'D412-702-103A', 'D412-702-103B', 'D412-702-105A', 'D412-702-105B', 'D412-702-107A', 'D412-702-107B', 'D412-702-109B', 'D412-702-111A', 'D412-702-111B', 'D412-702-113A', 'D412-702-113B', 'D412-702-115B', 'D412-702-117B', 'D412-702-121B', 'D412-702-121BRevA', 'D412-702-123B', 'D412-702-123BRevA', 'D412-702-301', 'D412-702-303', 'D412-702-305', 'D412-702-307', 'D412-702-309', 'D412-702-311', 'D412-702-313', 'D412-702-315', 'D412-702-317', 'D412-702-319', 'D412-702-321', 'D412-702-323', 'D412-702-341', 'D412-702-343', 'D412-702-345', 'D412-702-347', 'D412-

D412-702-013	Main Warehouse	148987	8/23/2016	1.0000	QC21	CHG002
Shoulder Harness loops over FG029 existing lap belts, 5 Man Fwd Facing						

Total: 1.0000

D412-702-021	Main Warehouse	162737	8/28/2017	1.0000	QC21	CHG004
Shoulder Harness,4 Point Attachment,13 Man Configuration						

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Total: 1.0000

D412-702-025	Main Warehouse	155786	2/22/2017	1.0000	QC21	CHG002
Shoulder Harness,4 Point Attachment,4 Man Aft Facing						

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Total: 1.0000

D412-702-059	Main Warehouse	147642	8/16/2016	4.0000	QC21	CHG001
Grommet						

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Total: 4.0000

D412-702-069	Main Warehouse	158688	4/20/2017	3.0000	QC21	CHG001
Grommet						

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Total: 3.0000

D412-702-071	Main Warehouse	158550	7/4/2017	1.0000	QC21	CHG003
Comfort Crew Shoulder Harness						

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	Main Warehouse	161867	8/18/2017	1.0000	QC21	CHG003
	FG029					

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	Main Warehouse	162354	7/4/2017	1.0000	QC21	CHG003
	FG029					

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SEP 20 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

List Lots

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D412-702-071	Main Warehouse	162984	7/4/2017	1.0000	QC21	CHG003
Comfort Crew Shoulder Harness	FG029					

	Main Warehouse	162985	7/4/2017	1.0000	QC21	CHG003
	FG029					

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9-89

SEP 20 2017

Total: 5.0000

D412-702-101A	Premier	34223	11/27/2013	1.0000	QC21
Harness Assembly	Mezz				

Total: 1.0000

D412-702-101B	Premier	65010	11/27/2013	1.0000	QC21
Harness Assembly	Mezz				

Total: 1.0000

D412-702-103A	Premier	34224	11/27/2013	1.0000	QC21
Harness Assembly	Mezz				

Total: 1.0000

D412-702-103B	Premier	65011	11/27/2013	1.0000	QC21
Harness Assembly	Mezz				

Total: 1.0000

D412-702-105A	Premier	34225	11/27/2013	1.0000	QC21
Harness Assembly	Mezz				

Total: 1.0000

D412-702-107A	Premier	34226	11/27/2013	1.0000	QC21
Harness Assembly	Mezz				

Total: 1.0000

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List Lots

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By _____					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

List Lots

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D412-702-111A Harness Assembly	Premier Mezz	34228	11/27/2013	2.0000	QC21	
				Total:	2.0000	
D412-702-113A Harness Assembly	Premier Mezz	34229	11/27/2013	2.0000	QC21	
				Total:	2.0000	
D412-702-123B Harness Assembly	Premier Mezz	65022	1/15/2016	1.0000	QC21	CHG001
				Total:	1.0000	
D412-702-301 Harness Assembly	Main Warehouse ST468	159029	8/4/2017	1.0000	QC21	CHG001
	Main Warehouse ST468	161907	5/31/2017	1.0000	QC21	CHG001
				Total:	2.0000	
D412-702-303 Harness Assembly	Main Warehouse ST468	159035	6/16/2017	2.0000	QC21	CHG001
				Total:	2.0000	
D412-702-305 Harness Assembly	Main Warehouse ST468	159051	8/4/2017	1.0000	QC21	CHG001
				Total:	1.0000	
D412-702-307 Harness Assembly	Main Warehouse ST468	161941	7/24/2017	1.0000	QC21	CHG001
				Total:	1.0000	
D412-702-309 Harness Assembly	Main Warehouse ST468	159025	8/4/2017	1.0000	QC21	CHG001

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														

List Lots

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			Total:	1.0000		
D412-702-311	Main Warehouse	161658	5/31/2017	2.0000	QC21	CHG001
Harness Assembly	ST468					
	Main Warehouse	161964	5/31/2017	2.0000	QC21	CHG001
			Total:	4.0000		
D412-702-313	Main Warehouse	161659	5/31/2017	2.0000	QC21	CHG001
Harness Assembly	ST468					
	Main Warehouse	161973	5/31/2017	2.0000	QC21	CHG001
			Total:	4.0000		
D412-702-315	Main Warehouse	127728	3/3/2015	1.0000	QC21	CHG001
Harness Assembly	ST468					
			Total:	1.0000		
D412-702-317	Main Warehouse	127807	11/9/2015	1.0000	QC21	CHG001
Harness Assembly	ST468					
			Total:	1.0000		
D412-702-319	Main Warehouse	135593	8/26/2015	1.0000	QC21	CHG001
Harness Assembly	ST468					
			Total:	1.0000		
D412-702-321	Main Warehouse	161660	5/31/2017	2.0000	QC21	CHG001
Harness Assembly	ST468					
	Main Warehouse	161985	5/31/2017	2.0000	QC21	CHG001
			Total:	4.0000		

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DQA: _____ Date: _____



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QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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D412-702-323	Main Warehouse	161661	7/19/2017	2.0000	QC21	
Harness Assembly	ST468					
	Main Warehouse	161913	7/19/2017	2.0000	QC21	CHG001
	ST468					

Total: 4.0000

D412-702-341	Main Warehouse	156935	3/16/2017	1.0000	QC21	CHG001
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Shoulder Harness, 3-Point
Att., Inertia Reel
Continuous Belt, 13 Man

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SEP 20 2017

Total: 1.0000

D412-702-343	Main Warehouse	163962	8/8/2017	2.0000	QC21	CHG001
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Shoulder Harness, 3-Point
Att., Inertia Reel
Continuous Belt, 5 Man Fwd

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SEP 20 2017

Total: 2.0000

D412-702-347	Main Warehouse	128058	5/19/2015	1.0000	QC21	CHG001
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Shoulder Harness, 3-Point
Att., Inertia Reel
Continuous Belt, 4 Man Side

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SEP 20 2017

Total: 1.0000

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Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

MPP

Date:	17.09.01	Job No.:	PI17-702-0X	ADR Yes/No:	N	ADR Date:		ECN #:	17- 628
Product No.:	D412-702	Created By:	VS	Approved By:		Checked By:	DS		
Product Name:	Shoulder Harness								

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)	Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
Director of Operations	Y	JLM		DQA / QA Coord.	Y	PS / ED	
Production Planning Man. / Production Planner	Y	SB / MP		QC Coordinator	Y	PD	
Supply Chain Director / Purchasing Manager	Y	RA / CL		Customer Support	Y	SW / LM	
Production Engineering Coord.	Y	DD		Customer Technical Support	Y	MB / ML	
Production Engineering Coord.	N	DL		Marketing	Y	WR	
Customer Order Processing	N	SL		Prod. Man. Solution Provider	Y	HM	

Reason for Change:

Changes from Customer Support

Documents Affected:

IIN-D412-702 Rev. H, IIN-D412-702-1 Rev. B, IIN-D412-702-2 Rev. B, IIN-D412-702-3 Rev. C, ICA-D412-702 Rev. 6

IF APPLICABLE: NCR: _____ PAR: Below CAR: _____ CIR: 16-65 URF: _____

PAPERWORK UPDATE ☒ PARTS MUST COMPLY ☐ PREVIOUS PARTS SATISFACTORY ☐

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3	Notify Augusta Westland	N			
4	Manufacturing Licensing Agreement Update	N			

#	Engineering Actions	Reqd	Resp	Notes	Complete
5	Required Documents/Drawings/Item ID's Under Review (URF)	N			
6	Update Master Document List (MDL)	Y	VS	MDL-D412-702 Rev. Y	17.08.22 VS
7	Update Document Record (DR)	N			
8	Update Product Compatibility Matrix	N			
9	Notify TC / FAA of Change (eg. ICA, 8110-3)	N			
10					

#	Document Control Actions	Reqd	Resp	Notes	Complete
11	Move / Update Electronic Files / Design Journal	Y	KJ		17.09.07
12	Update Product Specification Files (Bluefiles)	Y	KJ		17.09.07
13	Update Approved/Preliminary Dwg PDF Files	N			
14	Update Product Development Summary (STC applications)	N			
15	Update QSI 021 (TC/FAA STC) and/or STC Approval List	N			
16	Create/Update Parts / STC Database	Y	KJ		17.09.07
17	Update / Verify Airworthiness Release Certificate Database	Y	KJ	D412-702-081/-083/-084	17.09.07
18	Create / Update Change Record Form / Item Card Database	Y	KJ	D412-702-081/-083/-084 @CHG 001	17.09.07
19	Create / Update Packaging Process Plan (PPP)	Y	KJ	D412-702-081/-083/-084	17.09.07
20	Red Decals required on Packaging Process Plan (PPP)?	N			
21	Update Controlled Supplier Documents (Qpulse) Database	N			
22	Update Grey Project Binder / Electronic Project Folder	Y	KJ		17.09.07
23	Update D-Part / M-Drawing / DSI / DEO Master Binders	N			
24	Update "Royalty Paid to" attribute (Parts sold under Dart USA STC's)	N			
25					

Description / Action:

- PAR 17-586, PAR 17-600
- Create BOMs and Routes for new D412-702-081/-083/-084 kits
- Update Paperwork for D412-702 kits in stock
- Update D412-702-071/-073/-075 kits in stock per IIN-D412-702-3 Rev. C
- Update BOM/Routes for D412-071/-073/-075 per IIN-D412-702-3 Rev. C

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24
21
9-28

SEP 19 2017

ECN Verified & Complete: _____ Date: _____